

PRELIMINARY ISSUE

Page 1

Work Order ID 73542

Friday, September 02, 2011 8:53:08 AM

Item ID: D3806-1

Revision ID:

Item Name: Bar

Start Date: 9/2/2011 Start Qty: 4.00

Required Date: 9/16/2011 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: *W*

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3806

PB1

11/09/14



0.00

0.00

11/09/15

100

Mill Conv

Memo

Conventional Milling Machine

1-mill as per Dwg D3806

2-Deburr if necessary

110

QC5- Inspect part completeness to step on W/O

0.00

0.00

QC

Quality Control

Memo

*- inspect to PB1
Dry only
Dulor 116 (x6)*

150

Identify as per dwg & Stock Location: *W/A*

0.00

0.00

Packaging

Packaging

Memo

EL 11/9/20 (x6)

POSITIVE RECALL

EFFECTIVE *11/09/15* AUTH *W*

RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73542

Friday, September 02, 2011 8:53:08 AM



Page 2

Item ID: D3806-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar

Start Date: 9/2/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

H 11-09-20
(W)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, September 02, 2011 8:53:05 AM

Page 1

Work Order ID: 73542

Parent Item: D3806-1

Parent Item Name: Bar



Start Date: 9/2/2011

Required Date: 9/16/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-07-21 new issue DD verified by:ec
 IPP Rev:B 08-09-23 redesign DD verified by:EC
 IPP Rev:C 08-09-30 redesign DD verified by:EC
 D 11.06.03 re-design EC verified by:DD IPP rev

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No			100	f	225.3147	3.66	15.41053			



304 BAR .250 x .500



Location	Loc Qty	Loc Code
MAT006	129.3	
116148	78	
117842	51.3	
MAT050	96.0147	
117176	96.0147	

20.4 *[Signature]* 11/09/16

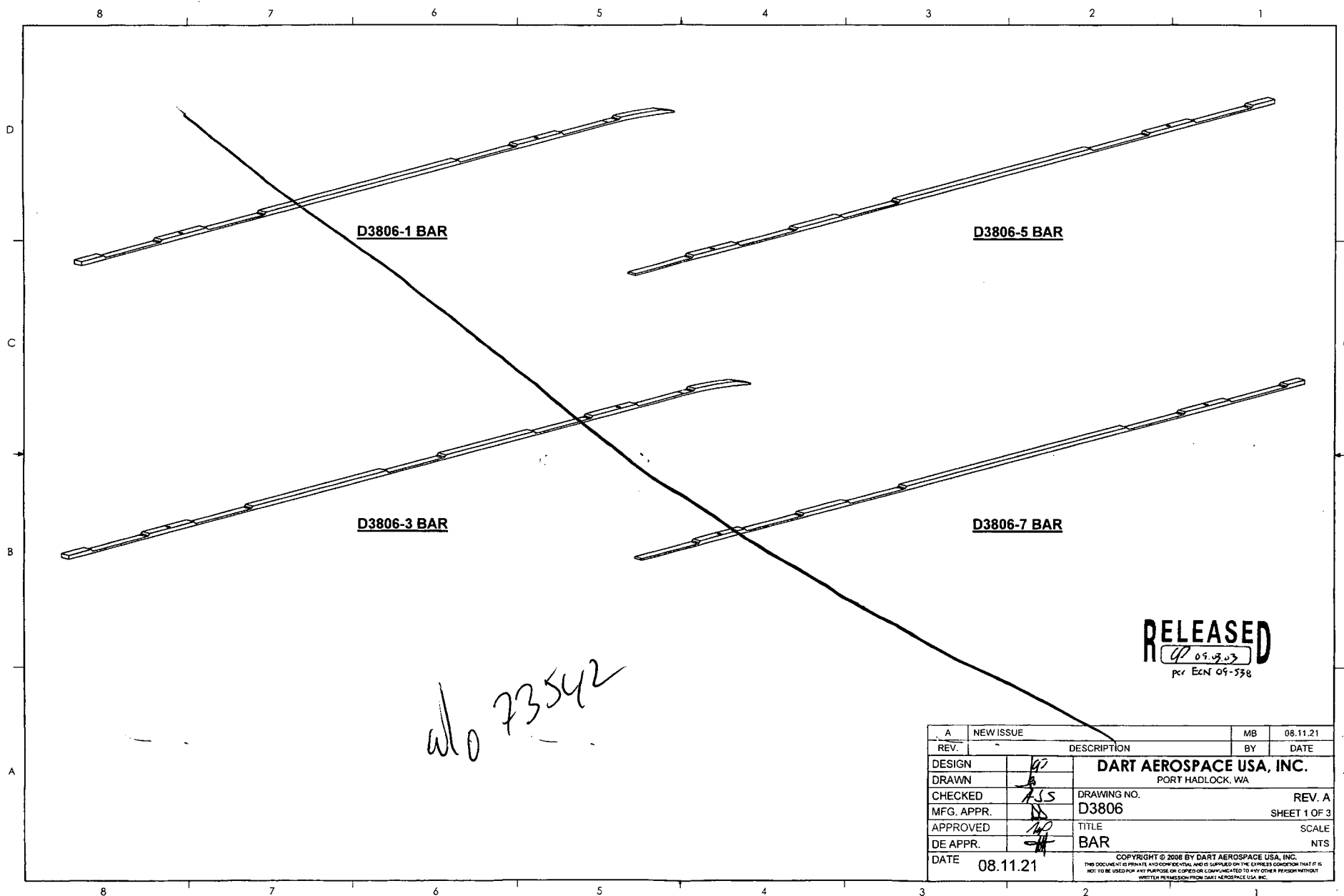
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

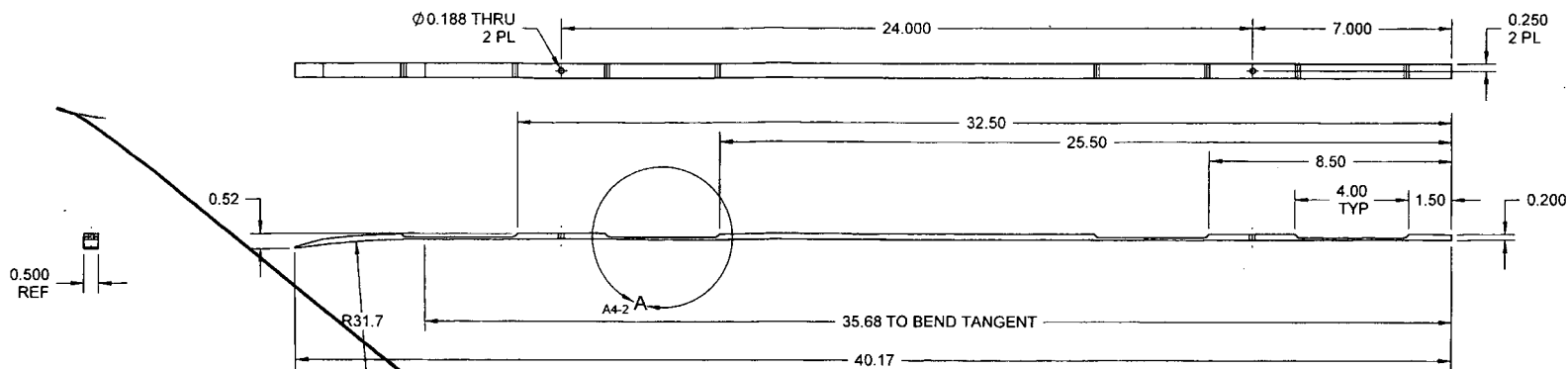
NOTE: Date & initial all entries



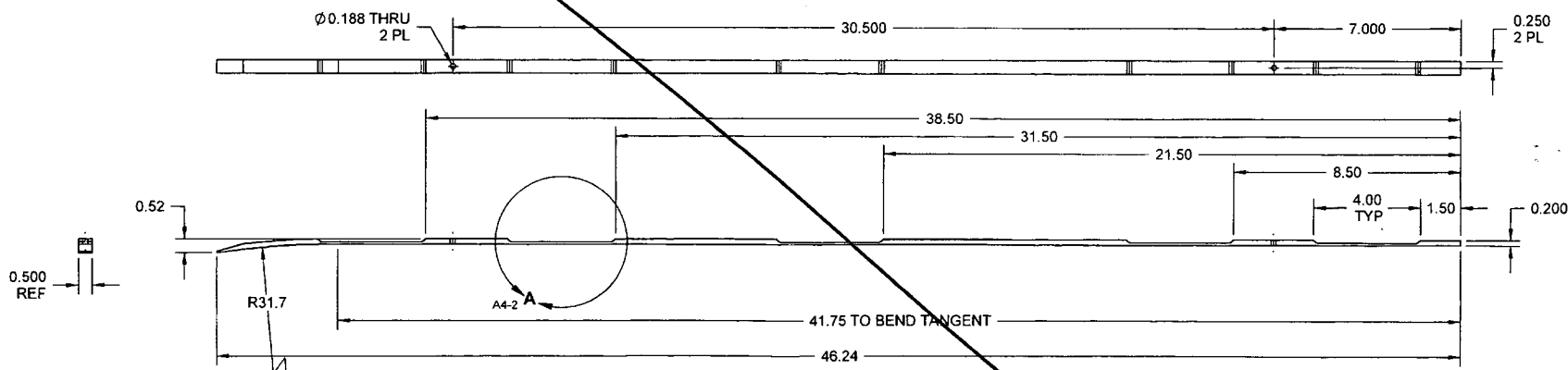
RELEASED
 09-09-03
 per ECN 09-538

A NEW ISSUE		MB	08.11.21
REV.		BY	DATE
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3806	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
DATE	08.11.21	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC.</small> <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1



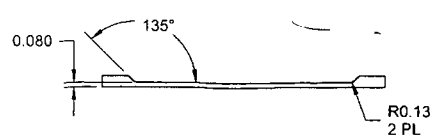
D3806-1 BAR



D3806-3 BAR

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.500 THICK
REF. DART SPEC. M304B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT:
D3806-1 = 0.87 lbs
D3806-3 = 0.98 lbs

73542



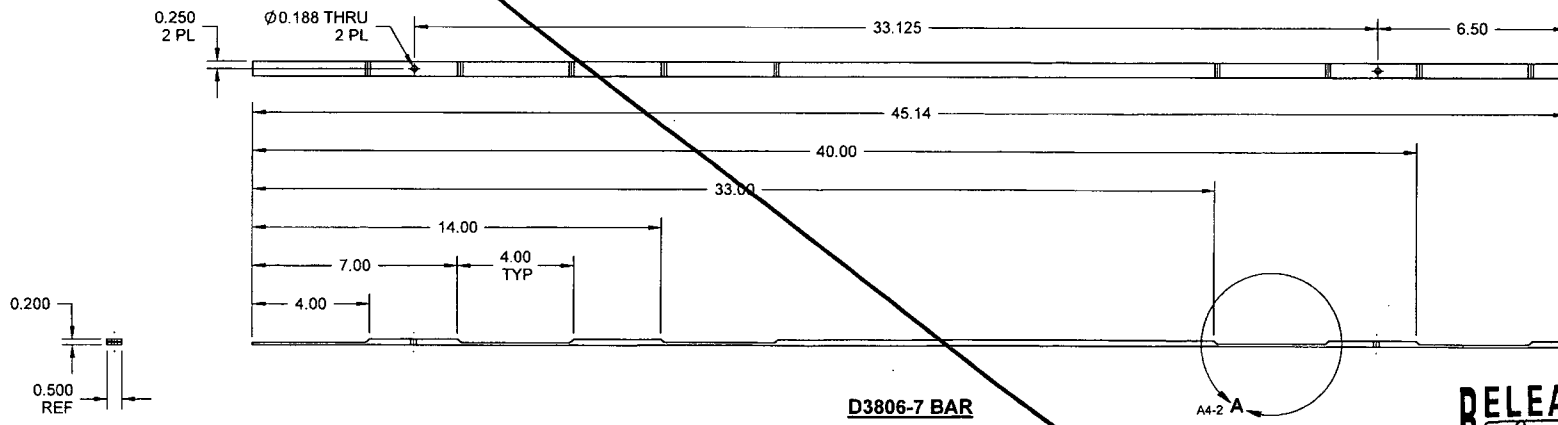
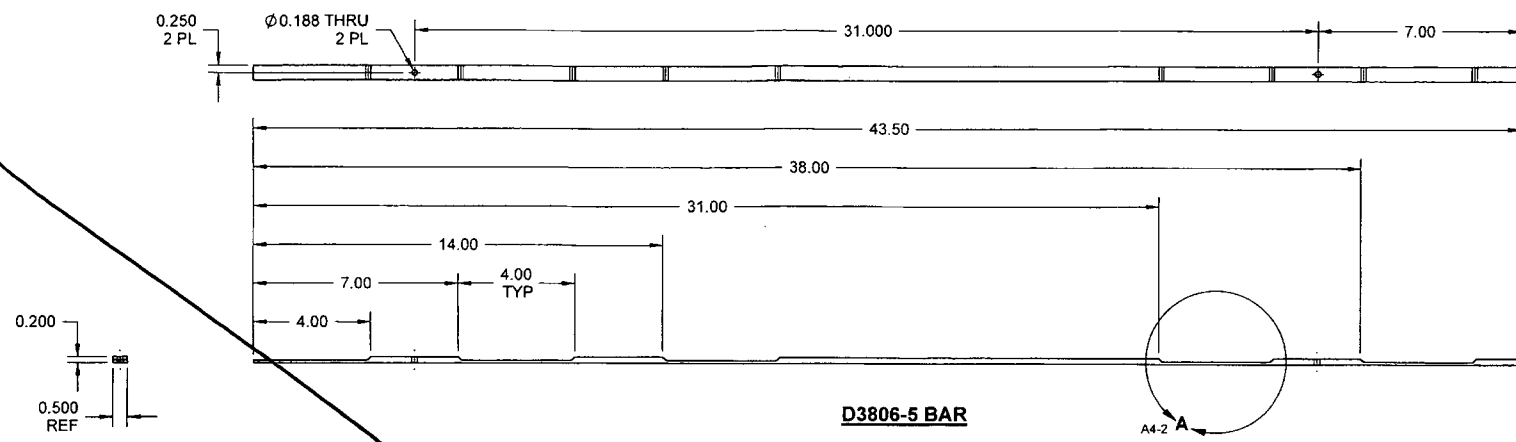
DETAIL A
TYP, SCALE 2X

RELEASED
09.03.03

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DRAWN	8	PORT HADLOCK, WA	
CHECKED	7/5	DRAWING NO.	REV. A
MFG. APPR.	D	D3806	SHEET 2 OF 3
APPROVED	40	TITLE	SCALE
DE APPR.	40	BAR	NTS
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



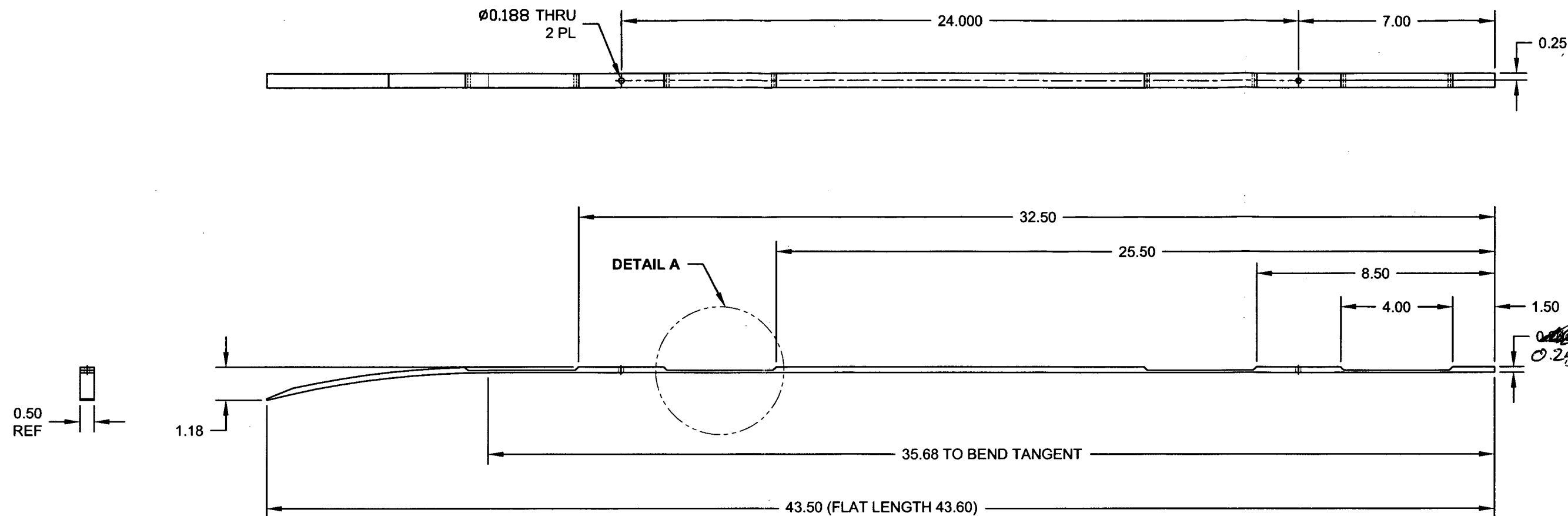
RELEASED
40 06.03.03

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.500 THICK
REF. DART SPEC. M304B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT:
D3806-5 = 0.91 lbs
D3806-7 = 0.97 lbs

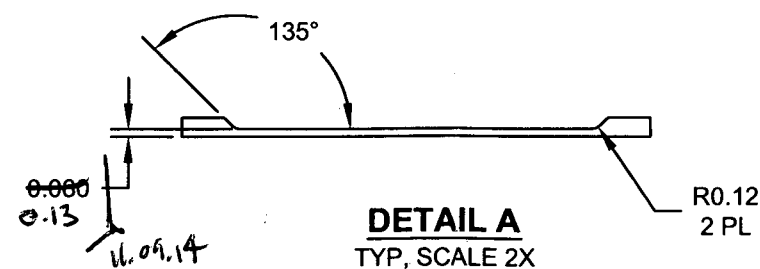
73542

DESIGN	40	DART AEROSPACE USA, INC.	
DRAWN	4	PORT HADLOCK, WA	
CHECKED	7.5	DRAWING NO. D3806	REV. A
MFG. APPR.	4	BAR	SHEET 3 OF 3
APPROVED	4	TITLE	SCALE
DE APPR.	4		NTS
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8 7 6 5 4 3 2 1



D3806-1 BAR



PRELIMINARY B1
11.05.31 AJS

73542

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.500 THICK 0.250 x 0.500 REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.97 lbs

PB1	PRELIMINARY	AJS	11.05.31
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. PB1
MFG. APPR.		D3806	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
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